

# Work Order ID 77765

**\*77765\***

Page 1

December-21-11 9:28:32 AM

Item ID: D350-748-101

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID: U/R

Stop **\*NS2\***

Item Name: Crosstube Installation, High Fwd

Start Date: 21/12/2011 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 13/01/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: M.L.J

Date: 11/12/21

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr							
D350-748-141	F U/R							

100

**\*100\***

DOCUMENT CONTROL

DC

Memo

Document Control

Photocopy bluefile & type labels per D350-748-101 CHG002

110

**\*110\***

BENDING MACHINE - CROSSTUBES

CNC Bend 1

Memo

CNC Delta 100 Bender

Bend tube as per Dwg D350-748-141 using CNC bender program D350F and Folio FT \_\_\_\_\_

120

**\*120\***

QC15- Crosstube Dimensional Check

QC

Memo

Quality Control

0.00

*Q 12.04.11*

*① SAO 12-04-03*

**SCRAP**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 77765

**\*77765\***

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Item ID: D350-748-101 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: U/R Stop **\*NS2\***  
Item Name: Crosstube Installation, High Fwd  
Start Date: 21/12/2011 Start Qty: 1.00 **\*1\*** Cust Item ID:  
Required Date: 13/01/2012 Req'd Qty: 1.00 **\*1\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
125		0.00							
<b>*125*</b>	<i>HandFXtube</i>	0.00							<i>CY 12 104/104 ①</i>
Hand Finishing Crosstubes	<p>Memo</p> <p>***Stress relief***</p> <p>Heat treat crosstube as per QSI010 4.3</p> <p>Temp: _____</p> <p>Start time: _____</p> <p>Finish time: _____</p>								
127	QC6- Inspect dimensions to drawing	0.00							
<b>*127*</b>	QC	0.00							
Quality Control	<p>Memo</p>								

*Issued P10 to Metcon*

*P10: 16638*

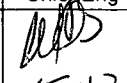
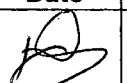

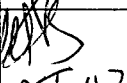
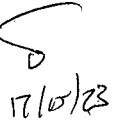
*per D350 D350-748-141 F1*

*↓ SCRAP TOO*  
*HIGH PR. 04.12*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12.04.11	110	Tube bent too high.	 Q51042 12/05/23	Too to trim SCRAP (P1204.11)	 12/05/23	 12/05/23	 Q51042 12/05/23	 12/10/23

**NOTE:** Date & initial all entries

**Work Order ID 77765****\*77765\***

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Item ID: D350-748-101

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**\*N900040100\***Setup Start **\*NS1\***

Revision ID: U/R

Stop **\*NS2\***

Item Name: Crosstube Installation, High Fwd

Start Date: 21/12/2011 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 13/01/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Crosstubes	0.00							
<b>*130*</b>									
Crosstubes	Memo	0.00							
Crosstubes	1-Drill Tube as per Dwg D350-748-141 Using DT8876 A,B & C Drill Jigs, Set-up drill table as per QSI 010								
	2-Deburr								
	3-Engrave Part # and Batch # as per Dwg D350-748-141								
	4-Remove all marks from tube within limits of D350-748-141								
	5- Apply a light coat of LPS3 on the interior of tube Batch: _____								
140	QC5- Inspect part completeness to step on W/O	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control	CHECK 10 DEG HOLES WITH DT8876E (EUROCOPTER CLAMP)								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 77765****\*77765\***

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Item ID: D350-748-101

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID: U/R

Stop

**\*NS2\***

Item Name: Crosstube Installation, High Fwd

Start Date: 21/12/2011 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 13/01/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start

**\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

Outsource process-Cadplate per QSI017 4.1.9.1

0.00

**\*150\***

Outsource3

Memo

0.00

Outsource process - Cad plate

Issue P/O: \_\_\_\_\_

Stress relief at 375° for 5 hours

Magnetic Particle Inspect per ASTM E1444

Cadium Plate per AMS-QQ-P-416B, Class 1, Type 2

Embrittle relief at 375° for 8 hours, Chromate Treat

Possible Supplier: Southwest United Industries

Ensure Certificate of Conformity is attached

160

Receive &amp; Inspect for Damage &amp; Mat'l Certs

0.00

**\*160\***

Packaging

Memo

0.00

Packaging

Ensure certificate of conformity is attached

170

QC5- Inspect part completeness to step on W/O

0.00

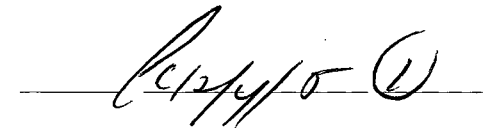
**\*170\***

QC

Memo

0.00

Quality Control



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries



December-21-11 9:28:32 AM

**Item ID:** D350-748-101

**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Revision ID: U/R

**Item Name:** Crosstube Installation, High Fwd

Stop \*NS2\*

**Start Date:** 21/12/2011 **Start Qty:** 1.00

**\*1\***

**Cust Item ID:**

**Required Date:** 13/01/2012      **Req'd Qty:** 1.00

**\*1\***

**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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180

0.00

**\*180\***

## SprayPaint

0.00

## SprayPaint

## Memo

## Spray Painting

1-Prime inside crosstube as per QSI 005 4.2  
2-Prime Outside of Tube as per Dart QSI 005 4.2

190

### QC14- Inspect Spray Paint

0.00

**\*190\***

QC

## Memo

0.00

## Quality Control

Then, Wrap in plastic bag to protect from scratches

200

0.00

**\*200\***

## Crosstubes

0.00

## Crosstubes

## Memo

## Crosstubes

- 1-Install Ground wire Insert,then insert screw and washer
- 2-Install Abrasion strips as per Dwg D350-748-141 & QSI 035.
- 3-Install supports Using Dt8876 as per Dwg D350-748-141,Torque to 60-80 IN-LBS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## December-21-11 9:28:32 AM

**\*77765\***

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**\*1\***

**Cust Item ID:**

**\* 1 \***

**Customer:**

**Reference:**

Run Start \*NR1\*

Stop \*NR2\*

**Insp.  
Stamp**

QC5- Inspect part completeness to step on W/O

0.00

**\*210\***

QC

## Memo

0.00

### Quality Control

220

## Pick Kit

0.00

\*220\*

## Packaging

## Memo

0.00

## Packaging

230

QC4- 100% Inspect kits for completeness

0.00

**\*230\***

QC

## Memo

0.00

## Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 77765****\*77765\***

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December-21-11 9:28:32 AM

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Item Name: Crosstube Installation, High Fwd  
Start Date: 21/12/2011 Start Qty: 1.00 **\*1\*** Cust Item ID:  
Required Date: 13/01/2012 Req'd Qty: 1.00 **\*1\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	Packaging	0.00							
<b>*240*</b>									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-748-101 Location: _____ PPP Rev: _____								
250	QC21- Final Inspection - Work Order Release	0.00							
<b>*250*</b>									
QC	Memo	0.00							
Quality Control									

ME  
12-05-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

**Picklist Print**

Page 1

December-21-11 9:28:37 AM

Work Order ID: 77765

**\*77765\***

Parent Item: D350-748-101

**\*D350-748-101\***

Parent Item Name: Crosstube Installation, High Fwd

Start Date: 21/12/2011

Required Date: 13/01/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 06-07-05 JLM  
 IPP Rev:B Update qty of MS21042L5 06-09-12 KJ  
 IPP Rev:C Rev B 07-11-15 DD  
 IPP Rev D Combined manufacturing 08.04.02 EC verified by: DD  
 IPP Rev:E 08-06-24 revD as per dwg DD verified by:EC IPP Rev:F  
 10.08.04 added QSI010 4.3 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D350-748-141TRN		Manufactured	No			110	Each	0.0000	1	1			
<b>*D350-748-141TRN*</b>							B74677		**	SAP		12-04-03	
Crosstube Turning Detail													
ALS4-1032-225		Purchased	No			200	Each	1,348.000	1	1			
<b>*AI S4-1032-225*</b>									**				
Insert													
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				ST281			1348						
				108696			199						
				110768			62						
				118386			858						
				118966			229						
AN960JD10	NAS1149D0363J	Purchased	No			200	Each	0.0000	1	1			
<b>*AN960.ID10*</b>									**				
Washer													
D2856-400		Manufactured	No			200	f	200.2721	1.181	1.243158			
<b>*D2856-400*</b>									**				
Abraison Strip													
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				ST409			200.2721						
				63735			0.6696						
				68076			0.3149						
				71164			21.66						
				73491			177.6276						

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item: D350-748-101

**\*D350-748-101\***

Parent Item Name: Crosstube Installation, High Fwd

Start Date: 21/12/2011

Required Date: 13/01/2012

Start Qty: 1.00

Required Qty: 1.00

D3502-1	Manufactured	No	200	Each	23.0000	2	2
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**\*D3502-1\***

Support

**\*\***

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST063	23	
72129	3	
73419	20	

MS21920-20	Purchased	No	200	Each	60.0000	2	2
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**\*MS21920-20\***

Clamp (per MIL-DTL-8783C)

**\*\***

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG050	60	
116799	10	
119386	50	

MS27039-1-10	Purchased	No	200	Each	41.0000	1	1
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**\*MS27039-1-10\***

Screw

**\*\***

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST291	41	
119307	3	
119531	38	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item: D350-748-101

**\*D350-748-101\***

Parent Item Name: Crosstube Installation, High Fwd

Start Date: 21/12/2011

Required Date: 13/01/2012

Start Qty: 1.00

Required Qty: 1.00

AN4-41A Purchased No

220

Each

285.0000

8

8

**\*AN4-41A\***

**\*\***

Bolt

Location

Loc Qty

Loc Code

ST360

285

115108

3

115705

7

117619

50

117795

25

118451

50

118838

50

119328

100

AN4-6A Purchased No

220

Each

4,130.000

16

16

**\*AN4-6A\***

**\*\***

Bolt

Location

Loc Qty

Loc Code

ST356

4130

119017

4130

AN5-32A Purchased No

220

Each

231.0000

4

4

**\*AN5-32A\***

**\*\***

Bolt

Location

Loc Qty

Loc Code

ST339

231

118422

6

118628

50

118983

25

119328

100

119862

50

AN960JD416 NAS1149D0463J Purchased No

220

Each

0.0000

32

32

**\*AN960JD416\***

**\*\***

Washer

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item Name: Crosstube Installation, High Fwd

Start Date: 21/12/2011

Required Date: 13/01/2012

Start Qty: 1.00

Required Qty: 1.00

MS21042L5

Purchased

No

220

Each

2,130.000

4

4

**\*MS21042L5\***

**\*\***

Nut

Location

Loc Qty

Loc Code

ST300

2130

116105

5

116548

43

117611

52

118179

496

118910

34

119109

1500

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

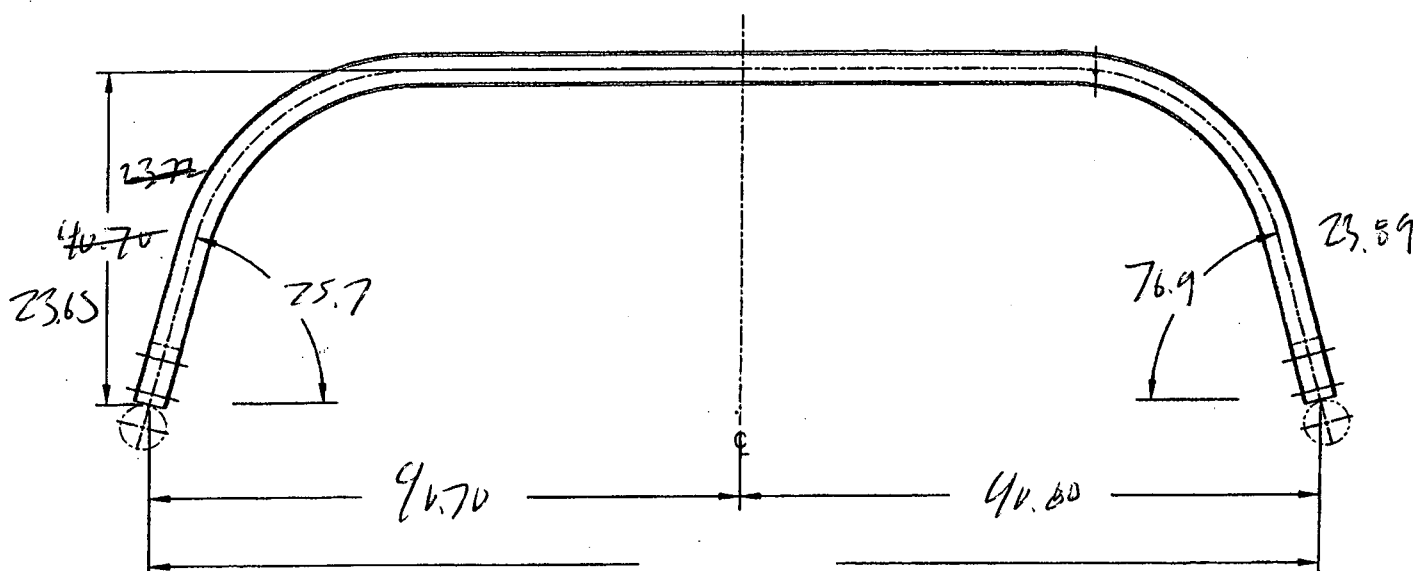
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 77765
<b>Description:</b> Crosstube High Fwd (AS350/355)		<b>Part Number:</b> D350-748-101
<b>Inspection Dwg:</b> D350-748-141	<b>Rev:</b> F	<b>Page 1 of 1</b>

Required Dimension	Min	Max
Height	23.13	23.37
1/2 Span	40.78	41.02
Angle	75	77
Total Span	81.56	82.04



Comments
Twist 0.273
SEP 12.04.11

QC15 Inspection	
Date	

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	10.08.23	Dwg Rev updated	KJ	
C	11.11.07	Dwg Rev updated	KJ	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



Item	Qty -141	Part Number	Description
1	X	D350-748-141	CROSSTUBE ASSEMBLY (AS 350/355 HI FWD)
2	1	D6015-125	CROSSTUBE (OR D6017-115)
3	2	D3502-1	SUPPORT
4	2	D2856-400-710	ABRASION STRIP
5	1	AELS-1032-225	INSERT
6	1	NAS1149D0363J	WASHER (OR AN960JD10)
7	2	MS21920-20	CLAMP (PER DART SPEC. M-MS21920-20)
8	1	MS27039-1-10	SCREW

#### GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6015-125 OR D6017-115  
FINISHED LENGTH = 110.270±0.06
- 2) FINISH: MAGNETIC PARTICLE INSPECT PER DART QSI 038 4.2  
CADMIUM PLATE PER AMS-QQ-P-416B, CLASS 1, TYPE II  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: DART PART NUMBER "D350-748-141" AND BATCH NUMBER ON INSIDE OF CUFF  
PER DART QSI 044 6.4 (VIBRATING STYLUS)
- 7) WEIGHT: 30.45 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE, EXCEPT FOR Ø0.297 HOLE.
- 9) BLEND OUT ALL EDGES FROM MACHINING LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.  
NOTE: ALL HOLES ARE DRILLED AFTER BENDING.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) HEAT TREAT TO MIN. 180 KSI PER MIL-T-6736 OR AMS 2759-1C AFTER TURNING. ACCEPTABLE TO VERIFY TENSILE STRENGTH BY HARDNESS TEST PER ASTM E18 TO 40-45 HRC.
- 12) INSTALL D2856-400-710 ABRASION STRIPS WITH A GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D3502-1 SUPPORT, PER QSI 035.
- 13) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO CRACKING/CHIPPING/GROOVES.
- 14) TORQUE CLAMPS 60 TO 80 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.
- 15) MAX TWIST AFTER BENDING: WITH XTUBE LAYED FLAT ON SURFACE, THE DIFFERENCE BETWEEN CUFF HEIGHTS FROM THE SURFACE MAY BE NO LARGER THAN 0.25 (ZN C1-3).

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO. 77765 M.L.J

11/12/21

UNDER REVIEW

11.07.21

RELEASED  
2011-01-18  
AM

F	ADD HRC TEST OPTION (B8-1) PER PAR 09-040, ADD TWIST LIMIT (A8-1, C1-3), ADD D6015-125 OPTION (C8-1), STOCK DIM NOW MACHINED (D1-4)	CP	10.11.23
E	REVISE GENERAL NOTES; UPDATE TO CURRENT ADD STANDARDS; RELOCATED FLAG #6 PER PAR 08-046 (ZN A6-3); TOLERANCES (ZN C6-3, D1-3)	RF	09.09.30
D	MAG. PARTICLE AND CAD PLATE AS MFD.	CP	06.10.31
C	ADD CAD PLATING	CP	06.08.14
B	ADD D6017-115 & PRIME AND PAINT	CP	06.06.30
A	NEW ISSUE	CP	06.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.11.23		
<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA			
DRAWING NO.		REV. F	
D350-748-141		SHEET 1 OF 4	
TITLE		SCALE	
CROSSTUBE (AS 350/355 HI FWD)		NTS	
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W/O:		WORK ORDER CHANGES					
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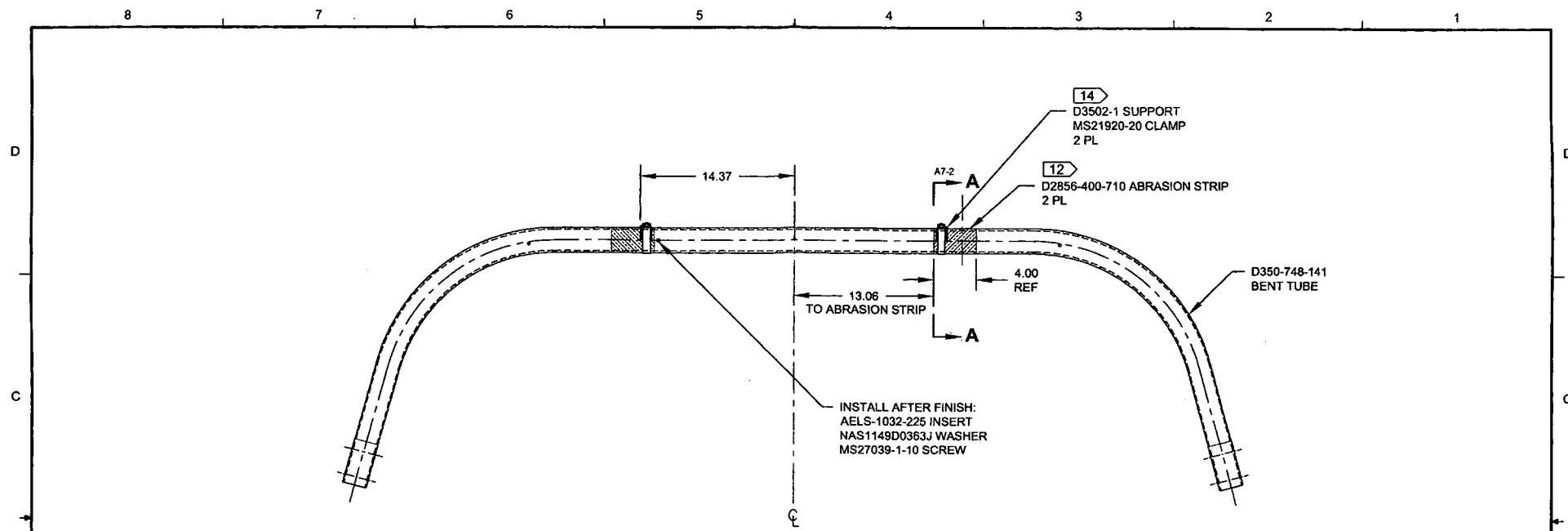
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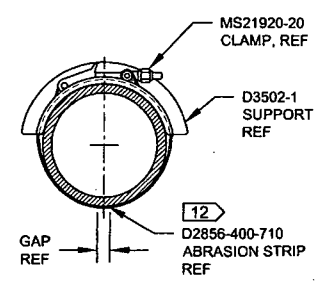
77765



**D350-748-141  
ASSEMBLY DETAIL**

UNDER REVIEW  
CP 11.07.11

RELEASED  
2011-01-30



**SECTION A-A** D4-2  
SCALE 4X

DESIGN	CP	<b>DART AEROSPACE LTD</b>	
DRAWN	CP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	CP	DRAWING NO.	REV. F
MFG. APPR.	CP	D350-748-141	SHEET 2 OF 4
APPROVED	CP	TITLE	SCALE
DE APPR.	CP	CROSSTUBE (AS 350/355 HI FWD)	NTS
DATE	10.11.23	<small>COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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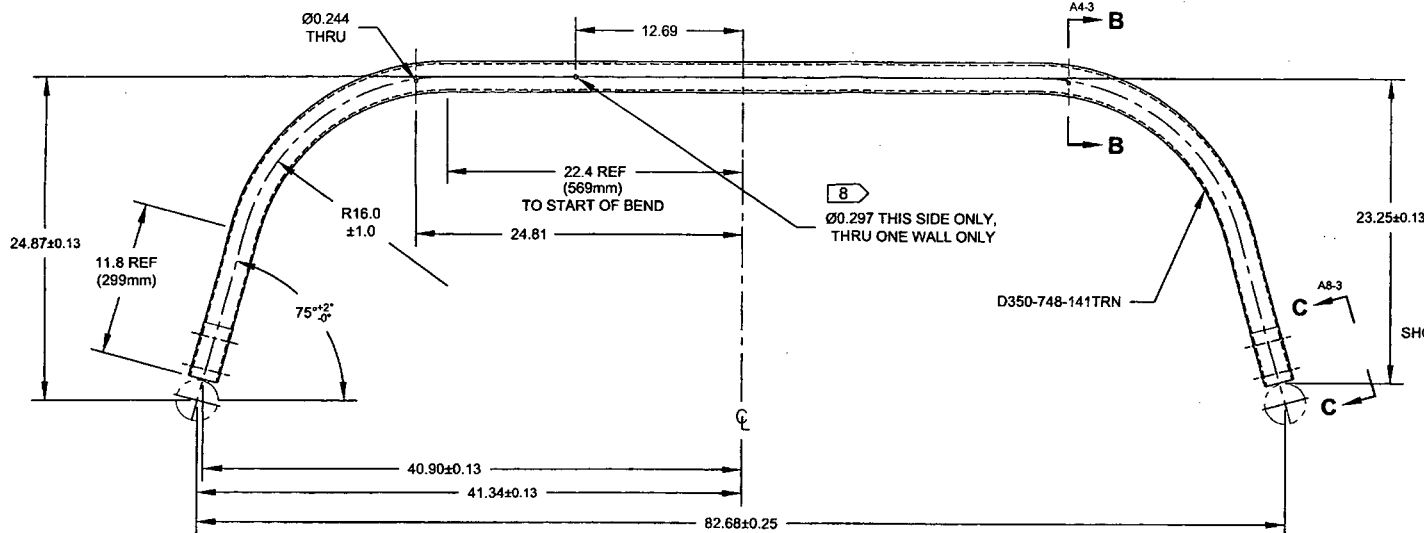
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

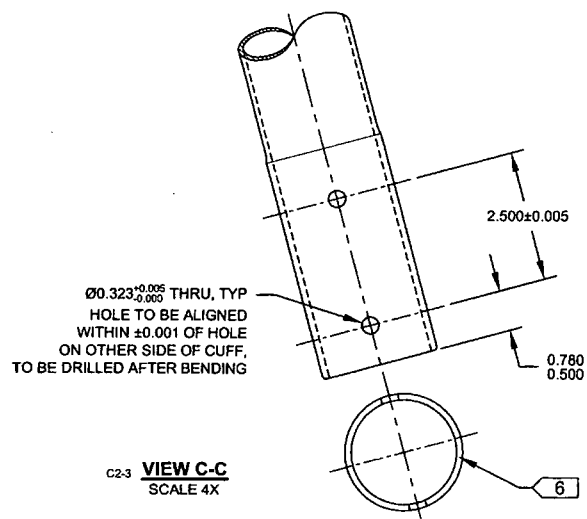
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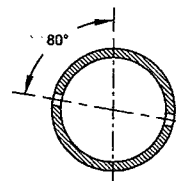
77765



**D350-748-141**  
**BENDING AND DRILLING DETAIL** 10



C2-3 **VIEW C-C**  
SCALE 4X



**SECTION B-B** D3-3  
SCALE 4X

UNDER REVIEW

RELEASED  
2011-01-18

DESIGN	DP	<b>DART AEROSPACE LTD</b>	
DRAWN	DP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	h	DRAWING NO.	REV. F
MFG. APPR.	h	D350-748-141	SHEET 3 OF 4
APPROVED	h	TITLE	SCALE
DE APPR.	h	CROSSTUBE (AS 350/355 HI FWD)	NTS
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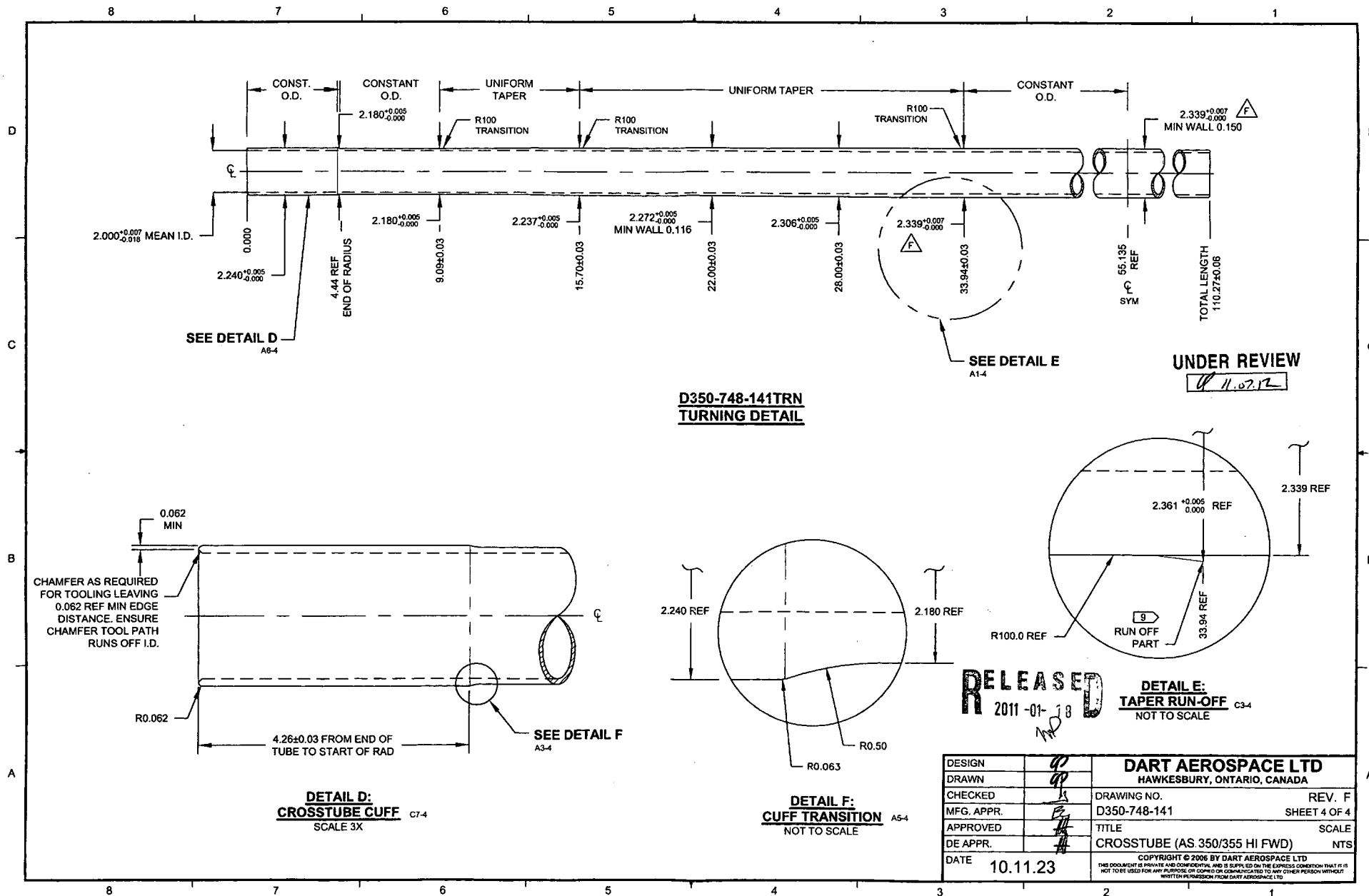
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77765



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DRAWING NO. D350-748-141	TITLE CROSSTUBE (AS 350/355 HI FWD)	REV. F	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D350-748-141-F-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>JP</i>	CHECKED <i>A</i>	MFG. APPR. <i>AS</i>	APPROVED <i>MD</i>		DE APPR. <i>TH</i>		
DATE 12.04.02	DATE 12.04.03	DATE 12.04.03	DATE 12.04.03		DATE 12.04.03		

**PURPOSE:**

ADD A STRESS RELIEF OPERATION FOLLOWING BENDING

**CHANGE:**

ADD

10) AFTER BENDING: STRESS RELIEF AT 650°F ± 25°F FOR A MINIMUM OF 2 HRS.  
AIR COOL TO AMBIENT TEMPERATURE  
(REF. AMS2759/1E)

# METCOR INC.

560 BOUL. ARTHUR-SAUVÉ  
ST-EUSTACHE, QC, J7R 5A8

Tel: 450-473-1884 / Fax: 450-491-5498

## Certificat de Conformité Détaillé

Detailed Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
175005	1

CLIENT / customer 215

DART AEROSPACE  
1270 ABERDEEN  
HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE  
1270 ABERDEEN  
HAWKESBURY

ON K6A 1K7

1

COMMANDE DU CLIENT customer po	BON DE LIVRAISON DU CLIENT customer shipper no.	MATÉRIEL material	CODE DE TRAITEMENT mat'l heat code	NUMÉRO DE LOT lot number
PO16638		Steel		

### SPÉCIFICATIONS DU PROCÉDÉ processing specifications

STRESS REL

SAE AMS 2759/1 REV.E

EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results
Visual			

QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description
9	270	D350-748-101 (7) CROSS TUBE  (2) D350-748-201 CROSS TUBE  CONTENANT: 1 NIL

Operation	Temp. spécifiée Specified Temp	Temps de trempé Spécifié Specified Soak Temp	Atmosphère	Carbone Carbon Potential	Q-Media Q-Temp	Four # Furnace #	Date Départ Start Date	Heure d'entrée Time In	Heure de sortie Time Out	Date Complétée Date complete
1,00 CONT. INIT.	LAVAGE		si nécessaire							
2,00 PREPARING	COMPTAGE									
3,00 STRESS RE	650 +/-25°F	2 hrs	air			701				
4,00 FINAL INSP							04-05-2012			04-05-2012

### COMMENTAIRES / comments

ALL THE HEAT TREATMENT PROCESSING PERFORMED ON THIS ORDER WAS ACCOMPLISHED USING HEAT TREATMENT EQUIPEMENT THAT MEETS THE REQUIREMENTS OF AMS 2759. ALL THE HEAT TREATMENT OPERATIONS WERE ACCOMPLISHED IN ACCORDANCE WITH THE REQUESTED/REQUIRED HEAT TREATMENT SPECIFICATION AND ALL REQUIRED VERIFICATIONS TEST HAVE BEEN PERFORMED AND DOCUMENTED. NO UNAUTHORIZED CHANGES OR DEVIATIONS TO REQUIRED HEAT TREATMENT SPECIFICATIONS OR PROCEDURES HAVE BEEN PERFORMED.

# METCOR INC.

560 BOUL. ARTHUR-SAUVÉ  
ST-EUSTACHE, QC, J7R 5A8

Tel: 450-473-1884 / Fax: 450-491-5498

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HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

1

APPROUVÉ par / Approved by:

*Stu Salame*



DATE: 2012-04-05

/ Nous certifions que toute l'information comprise sur ce rapport est exacte et conforme aux requis du client. / We certify that all the information on this report is exact and in accordance with the order requirements.



Metcor Inc.  
560, boul. Arthur-Sauvé  
St-Eustache (Québec) J7B 5A8  
Tél: 450-491-5498  
Télécopieur/Fax administration: 450-491-6454  
Télécopieur/Fax production: 450-491-6454

Certificat de conformité Certificate of conformity	
BON DE TRAVAIL order	CHARGEMENT load
175005	1

CLIENT / customer 215  
DART AEROSPACE  
1270 ABERDEEN  
HAWKESBURY

ON K8A 1K7

LIVRÉ À / shipped to:  
DART AEROSPACE  
1270 ABERDEEN  
HAWKESBURY

ON K8A 1K7

COMMANDE DU CLIENT customer po	BON DE LIVRAISON DU CLIENT customer shipper no.	MATÉRIEL material	CODE DE TRAITEMENT mat'l heat code	NUMÉRO DE LOT lot number
		Steel		

SPECIFICATIONS DU PROCÉDÉ  
processing specifications

STRESS REL

BAE AMS 2750/1 REV.E

EXIGENCE / requirement SPÉCIFICATIONS / specified TESTS EXÉCUTÉS / performed RÉSULTATS DE TESTS / results  
(level)

QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description
9	270	D350-748-141-F-1

COMMENTAIRES / comments

INSPECTEUR / inspector:

*Small*

DATE: 2012-04-05